

Split
Work Order ID 111703-2

Monday, January 20, 2014 9:22:58 AM

111703

Ship Thursday
Page 1

Item ID: D4775-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Strut Assembly

Start Date: 1/20/2014 Start Qty: ~~8.00~~ 1

8

Cust Item ID:

Required Date: 1/22/2014 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MF

Date: 1/4-1-20 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4775

C

110

Pick Kit

0.00

110

Large Fab

Packaging

Memo

0.00

Packaging

FF 14-05-23

120

0.00

120

Small Fab

Memo

0.00

Small Fab

1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG

A/R PROSEAL BATCH: 17120712

2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

FF 14-05-23

Work Order ID 111703

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Item ID: D4775-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut Assembly
 Start Date: 1/20/2014 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 1/22/2014 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC5- Inspect part completeness to step on W/O	0.00				1			
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130

QC

Quality Control

Memo

0.00

DAS
27
9-89

14/5/26

140	Identify as per dwg & Stock Location: <u>822ld6</u>	0.00				14		14-5-26	
-----	---	------	--	--	--	----	--	---------	--

140

Packaging

Packaging

Memo

0.00

DAS
26
9-89

150	QC21- Final Inspection - Work Order Release	0.00				ML5		1405-26	
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150

QC

Quality Control

Memo

0.00

⑪ 14-5-26

Picklist Print

Monday, January 20, 2014 9:22:57 AM

Page 1

Work Order ID: 111703

Parent Item: D4775-041

Parent Item Name: Strut Assembly

Start Date: 1/20/2014

Required Date: 1/22/2014

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.08.26 PB1 DD
VERF:JLM IPP REV:C 13.09.26 AS PER REV.B DD VERF:JLM
IPP REV:D 14.01.10 AS PER REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4775-1 Strut Tube		Manufactured	No	111079		110	Each	0.0000	1	8	FF		
D4777-1 Rod End Bearing		Manufactured	No	116087 ①		110	Each	30.0000	1	8	FF		
				FF 14-05-22									
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST123		30				8			
				110971		30				1	FF		
✓ D4776-1 - 110934 Basket Strut Clevis		Manufactured	No			110	Each	0.0000	1	8	FF		
D4776-5 Spacer		Manufactured	No	111095		110	Each	0.0000	4	32	FF		
AN3-10A Bolt		Purchased	No			110	Each	269.0000	2	16	FF		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		119				16			
				m125709		119							
				ST511		150							
				m127817		150							
MS21042L3 ✓ Nut		Purchased	No			110	Each	5,561.0000	2	16	FF		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST506		962							
				123900		962							
				ST509		4599							
				M127304		1000							
				M127410		3000							
				M127831		599				16			

Picklist Print

Monday, January 20, 2014 9:22:57 AM

Page 2

Work Order ID: 111703

Parent Item: D4775-041

Start Date: 1/20/2014

Required Date: 1/22/2014

Parent Item Name: Strut Assembly

Start Qty: 8.00

Required Qty: 8.00

MS21209-F615

Heli-Coil

Purchased

No

110

Each

34.0000

1

8

Location

Loc Qty

Loc Code

GA

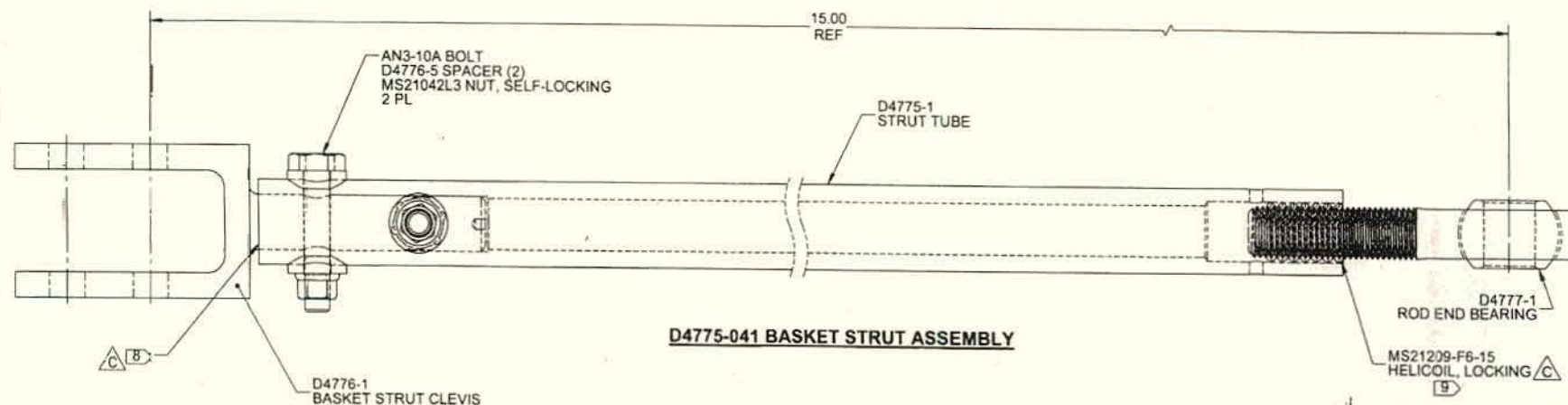
34

125097

34

8

ITEM	QTY	P/N	DESCRIPTION
	X	D4775-041	BASKET STRUT ASSEMBLY
1	1	D4775-1	STRUT TUBE
2	1	D4776-1	BASKET STRUT CLEVIS
3	4	D4776-5	SPACER
4	1	D4777-1	ROD END BEARING
5	2	AN3-10A	BOLT
6	2	MS21042L3	NUT, SELF-LOCKING
7	1	MS21209-F6-15	HELICOIL, LOCKING



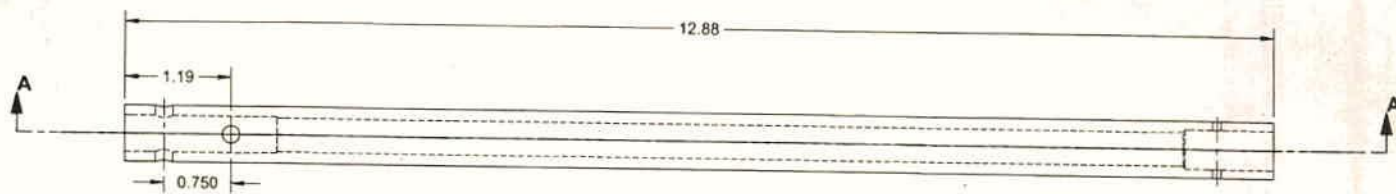
NOTES:

1. MATERIAL: N/A
2. FINISH: N/A
3. TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
4. UNITS: INCHES UNLESS OTHERWISE NOTED
5. BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6. IDENTIFICATION: PER QSI 044 6.1
7. WEIGHT: 0.45 lbs
8. APPLY PROSEAL 890 B-2 (PRC) TO THE STEM OF ITEM 2 TO PREVENT RATTLING
9. ENSURE HELICOIL DOES NOT BLOCK HOLE

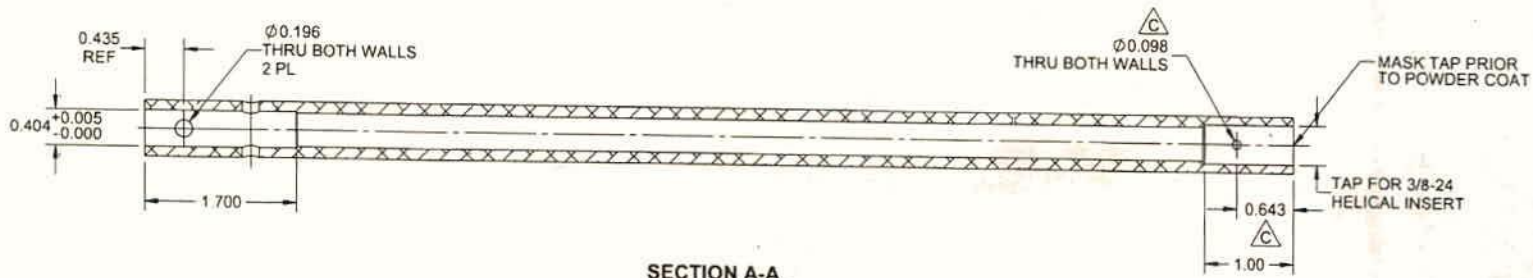
RELEASED
2014-01-07

C	ITEM 7 WAS F6-20, B2-2 Ø0.098 "WITNESS HOLE" ADDED. REASON: CUSTOMER FEEDBACK, ADDED NOTE 8. REASON: DESIGN IMPROVEMENT.	AJS	13.11.01
B	DELETED WELD PINS (-3) REPLACED WITH FASTENERS. REASON: PREVENT CRACKING & EASE OF MANUFACTURE. C8-2 HOLE PATTERN ON -1 REVERSED TO ENSURE FASTENERS CLEAR STRUCTURE. FINISH NOTE MOVED TO -1 (SHEET 2)	AJS	13.08.14
A	NEW ISSUE	AJS	13.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.		D4775	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET STRUT ASSEMBLY	NTS
DATE	13.11.01	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

111703



D4775-1 STRUT TUBE



SECTION A-A

RELEASED
2014-01-08

NOTES:

- 1) MATERIAL: 6061-T6/T62/T6510/T6511 SEAMLESS TUBING, $\phi 0.625 \times 0.125$ WALL
PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
OR AMS 4080 OR AMS 4082 OR AMS 4083
OR ASTM B210 OR ASTM B241
REF DART SPEC M6061T6T0.625W0.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.		D4775	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET STRUT ASSEMBLY	NTS
DATE	13.11.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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